

Date: Wednesday, 18/06/2008 1:27:45 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WELDMENT TOP PANEL
Job Number	: 39934		
Estimate Number	: 13030		
P.O. Number	:	Part Number	: D36505
This Issue	: 18/06/2008 S.O. No. :	Drawing Number	: D3650 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 36943	Material	:
Written By	:	Due Date	: 07/07/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JUL 08.6.18</u>		
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC		
	: Est Rev:B ECN 1113P 08-01-22 DD		
	: Est Rev:C ecn1162 08-04-02 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



3.



Comment: Qty.: 0.8537 sf(s)/Unit Total : 1.7073 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 108415 HB 8-6-26

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3650
 Dwg Rev: B
 Prog Rev: B

HB 8-6-26

③

2-Deburr if necessary

HB 8-6-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-6-26



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/07/01 (K3)

5.0	BRAKE NC	NC BRAKE
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P10 →


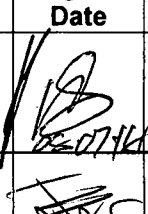
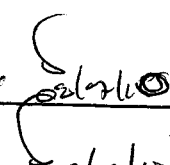


Comment: NC BRAKE
 Form as per Dwg D3650

HB 8-07-14 ②

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: <u>39934</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/10	5.0	Press operator bent D3650-5, according to Dwg. But Dwg operator error Bent opposite to Dwg. R.C. Dwg's are not consistent to each other R.C. Human error		Scrap and Destroy Replace BA 108415 08/01/10				
				Fix Dwg so they can be Bent correctly				

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:27:46 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 39934

Part Number: D36505

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/4/15 (13)

7.0

D36507

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~2.0000~~ Each(s)
SEAL 3.000

batch

B39950

FF 08-07-17 (3)

8.0

D36509

Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~2.0000~~ Each(s)
ANGLE 3.000

batch

B39951

FF 08-07-17 (3)

9.0

AN960C4

WASHER



Comment: Qty.: 12.0000 Each(s)/Unit Total: ~~24.0000~~ Each(s)
WASHER 36.000

batch

M106431

FF 08-07-17 (3)

10.0

NAS9307M403

~~CR 3223-4-03~~ RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total: ~~24.0000~~ Each(s)
RIVET 36.000

batch

~~M106431~~ M105940

FF 08-07-17 (3)

11.0

MS20427M33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: ~~16.0000~~ Each(s)
Rivet 24.000

batch

M106993

FF 08-07-16 (3)

12.0

MS210603K

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~4.0000~~ Each(s)
Nut Plate 6.000

batch

M105938

FF 08-07-16 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:27:46 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 39934

Part Number: D36505

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS210623K

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~4.0000~~ Each(s)

Nut Plate

batch M 105938

6.000

FF 08-07-16

(3)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3650

FF 08-07-16

(3)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/17 (3)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location GA

08 08/07/17

(3)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/17

Job Completion



08.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

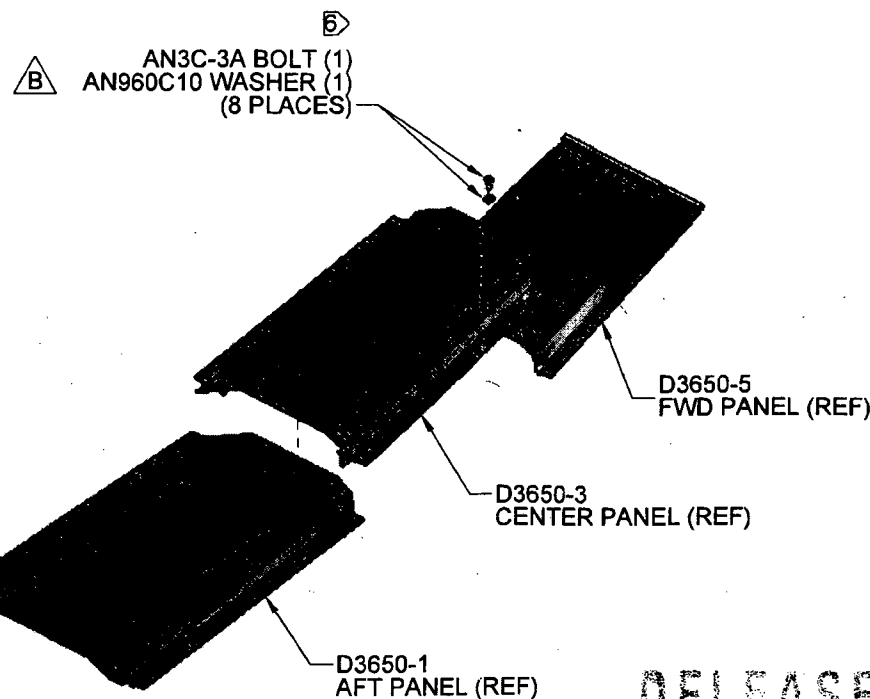
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

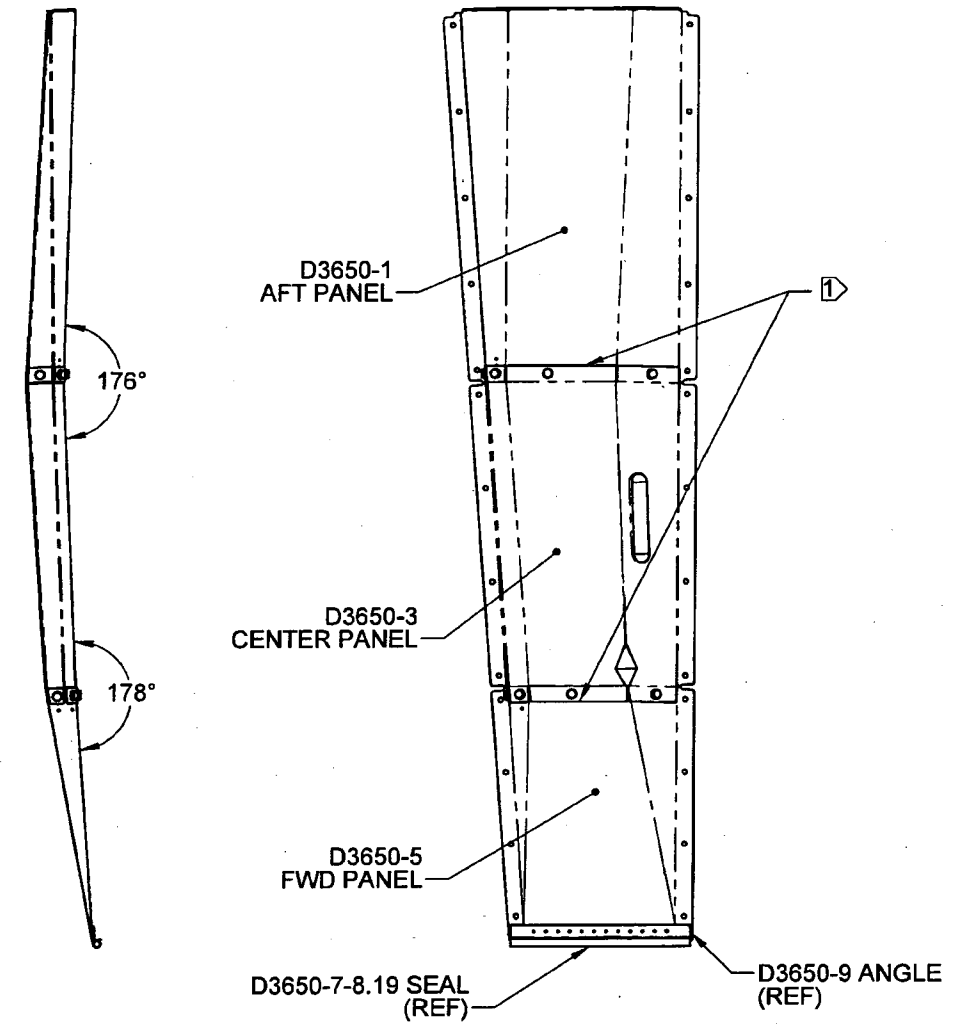
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



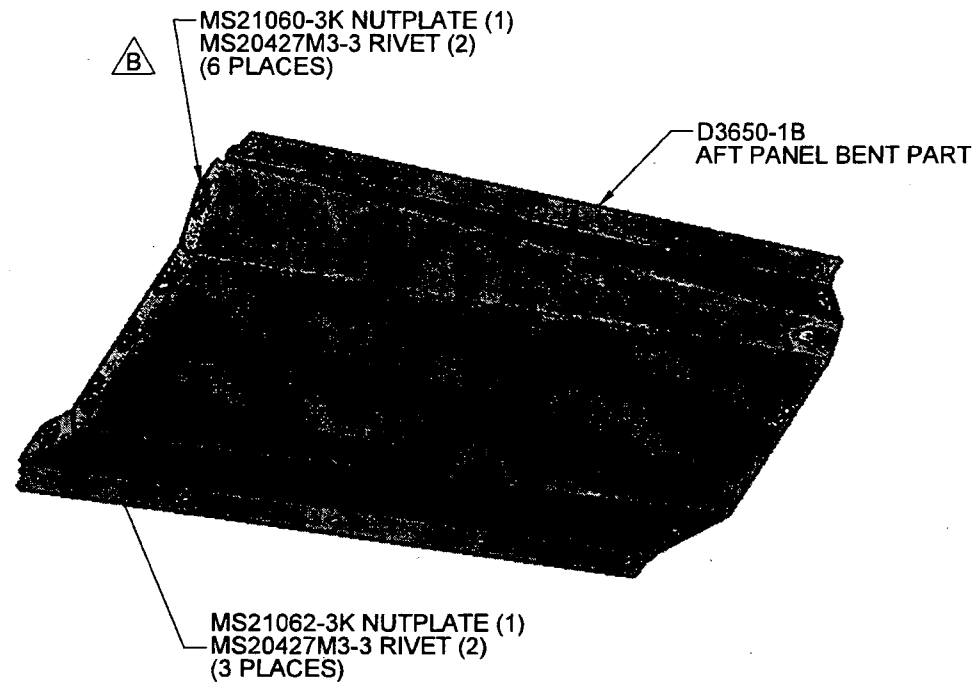
D3650-041 TUNNEL TOP PANEL ASSEMBLY

- NOTES:
- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: NONE
 - 6) TORQUE FASTENERS 15 TO 25 in-lb
 - 7) WEIGHT: 3.3 lbs

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 1 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TOP PANEL ASSEMBLY	1:8
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8 7 6 5 4 3 2 1



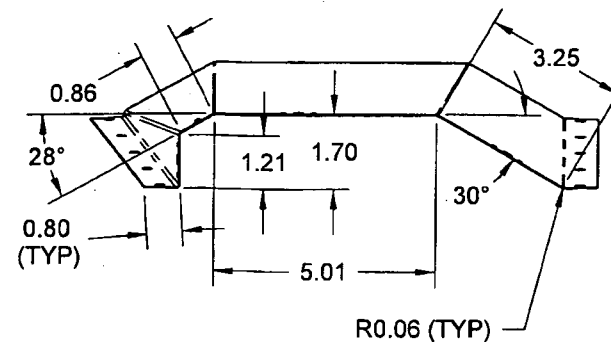
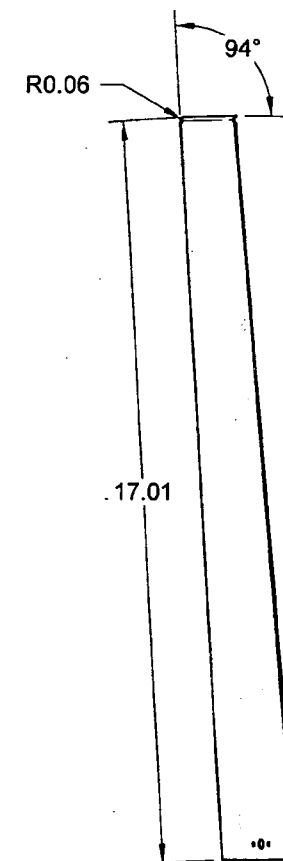
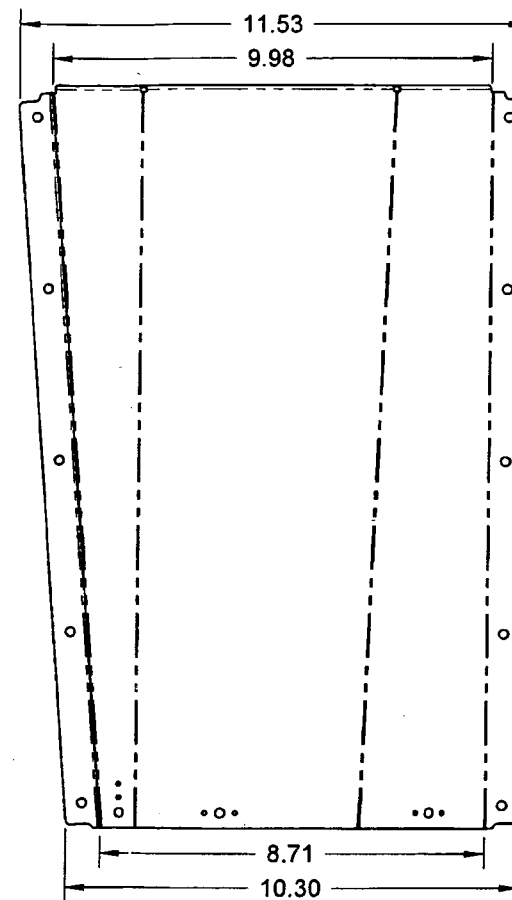
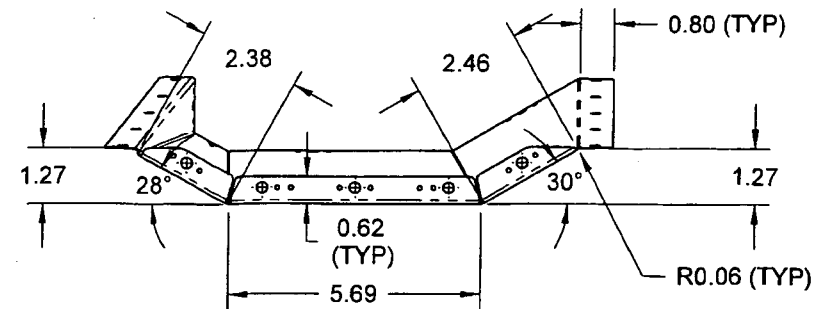
D3650-1 AFT PANEL

PART LIST

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: 1.3 lbs



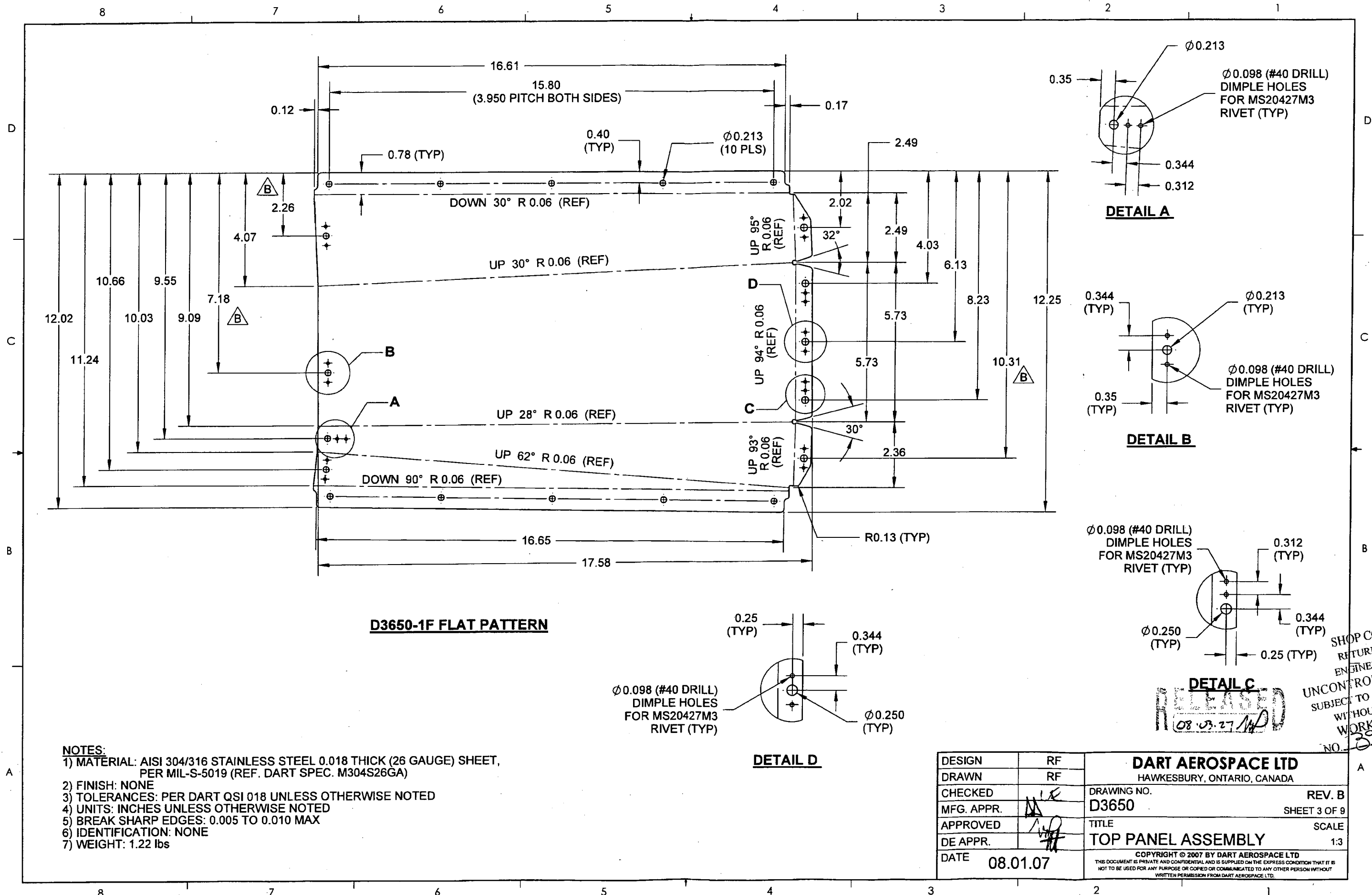
D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

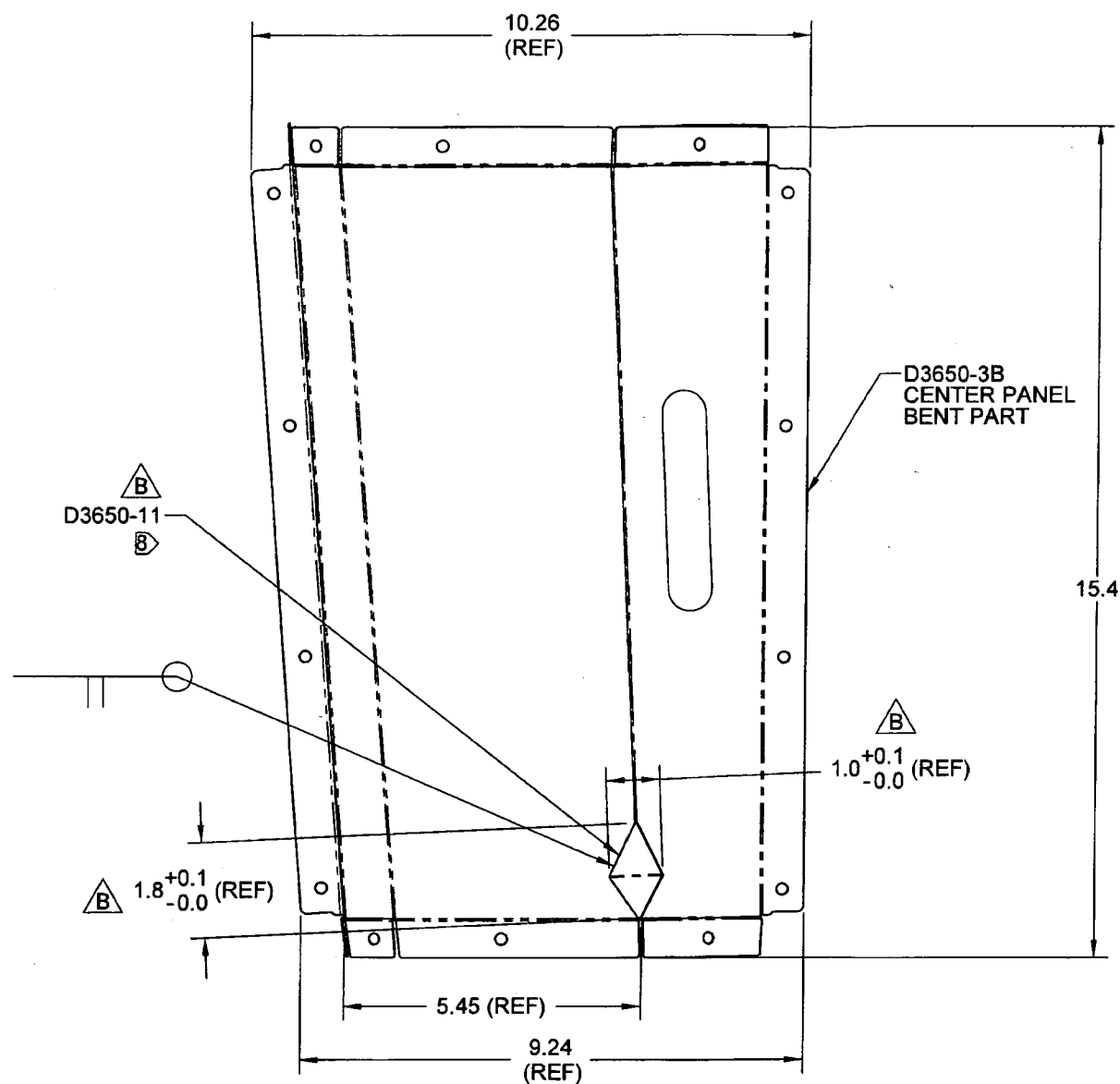
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08-03-27

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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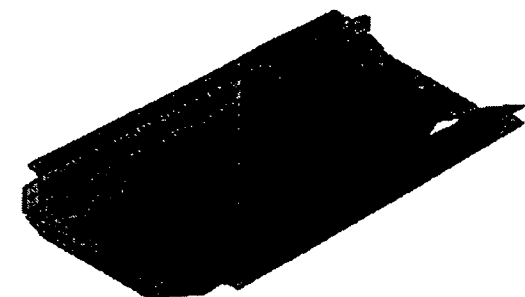
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8 7 6 5 4 3 2 1





D3650-3 CENTER PANEL



PART LIST

QTY	PART NUMBER	DESCRIPTION
-3	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

NOTES:

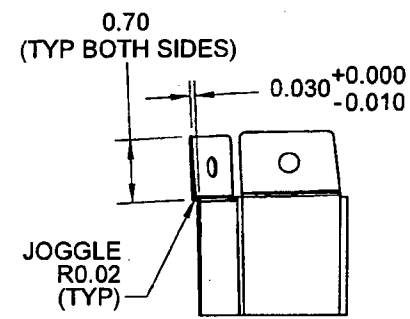
- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED



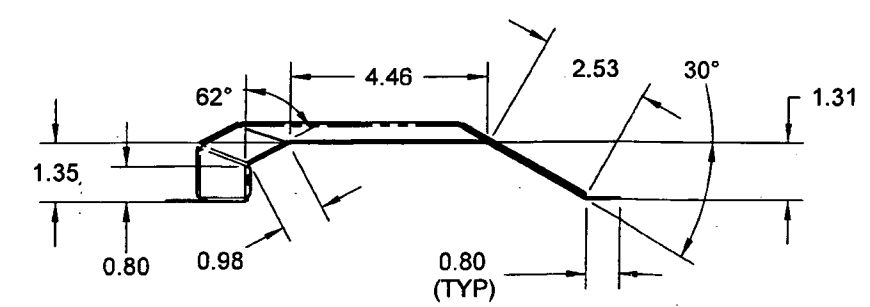
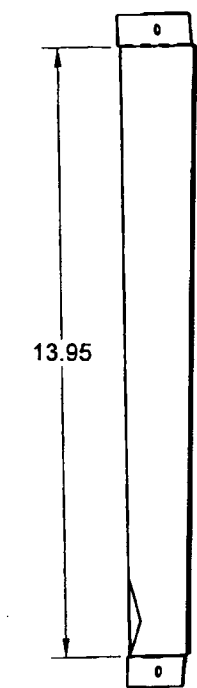
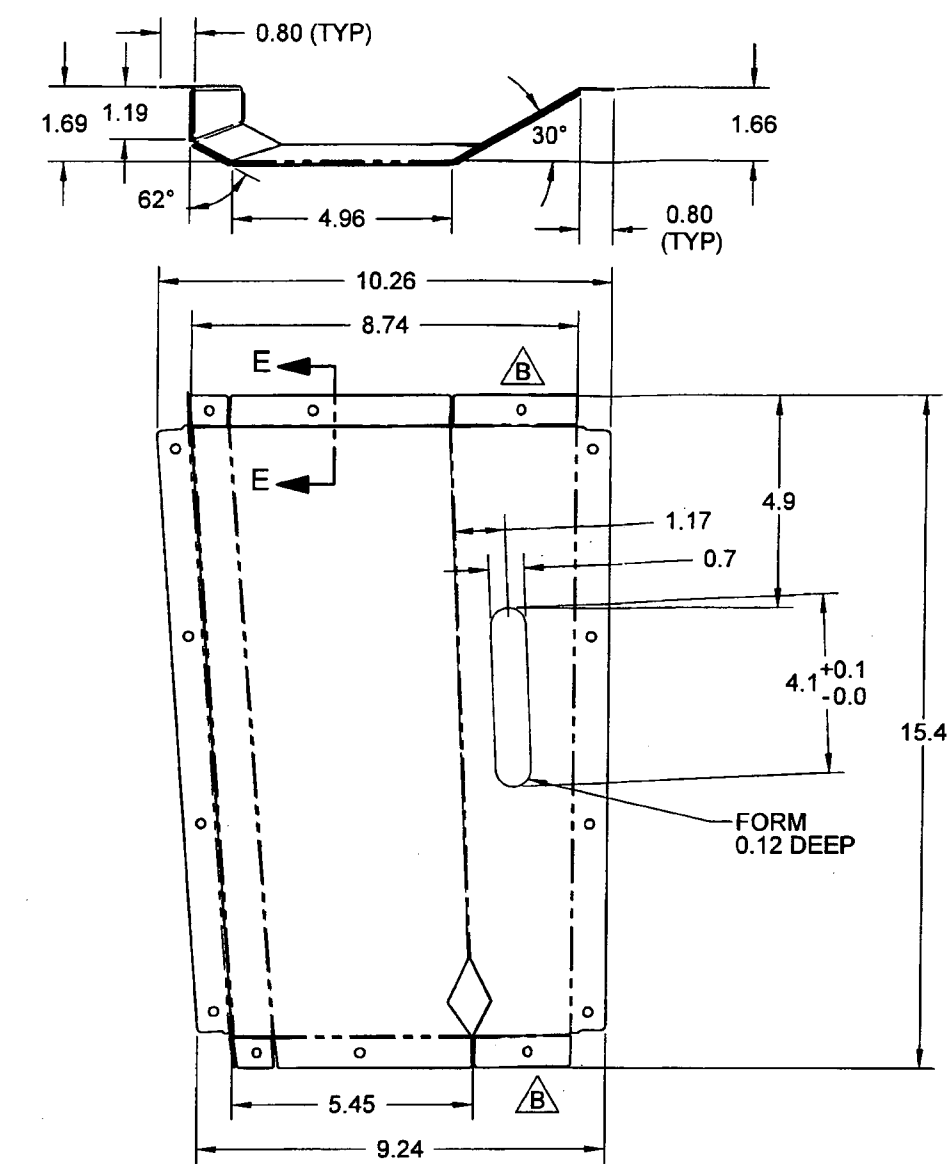
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NO 39939

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DRAWN	RF		
CHECKED	UC	DRAWING NO. D3650	REV. B
MFG. APPR.			SHEET 4 OF 9
APPROVED		TITLE TOP PANEL ASSEMBLY	SCALE 1:3
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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SECTION E-E



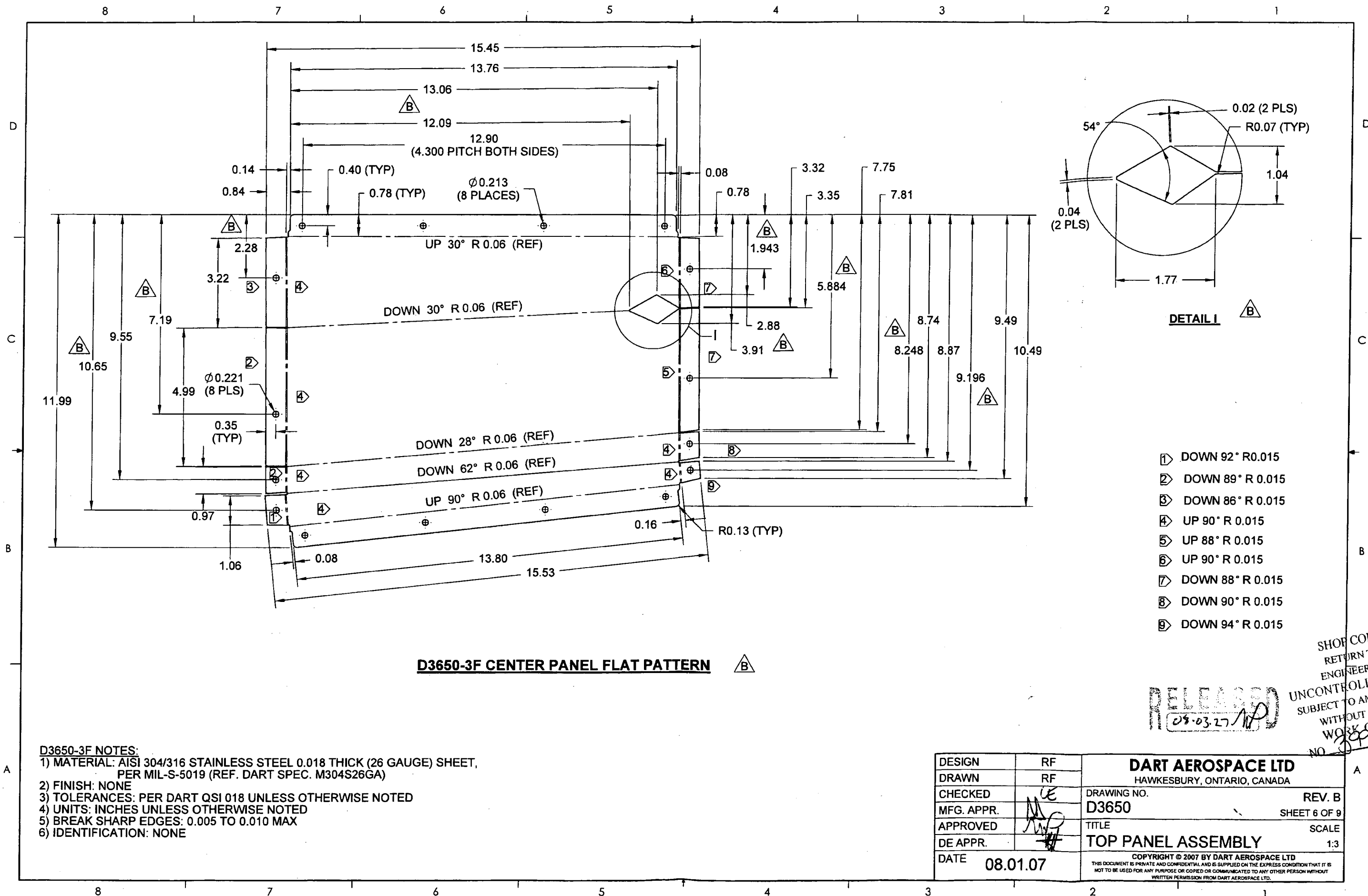
- NOTES:**
- 1) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

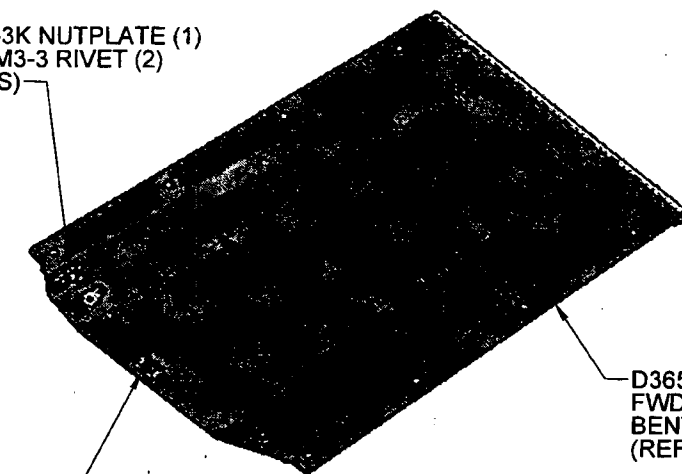
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3650
MFG. APPR.	<i>[Signature]</i>	REV. B SHEET 5 OF 9
APPROVED	<i>[Signature]</i>	TITLE TOP PANEL ASSEMBLY
DE APPR.	<i>[Signature]</i>	SCALE 1:4
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08-03-27
NO. 39934

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MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)



MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

B

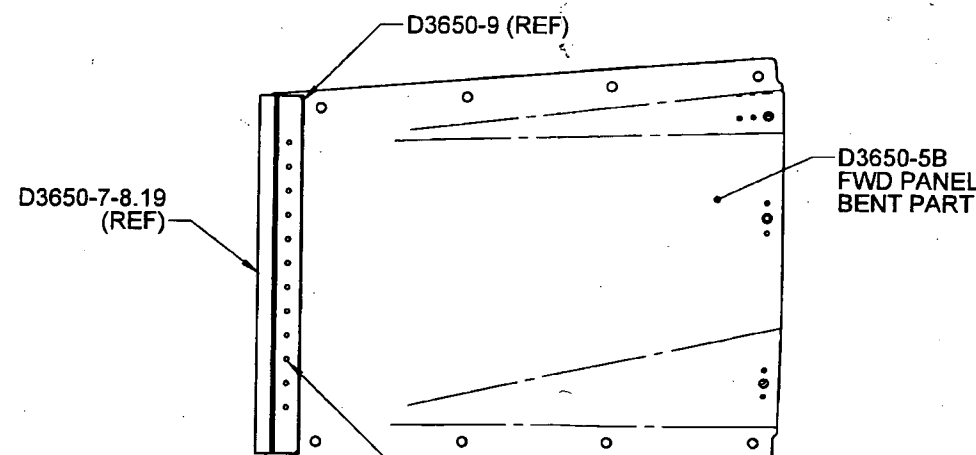
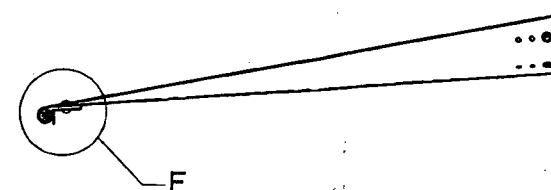
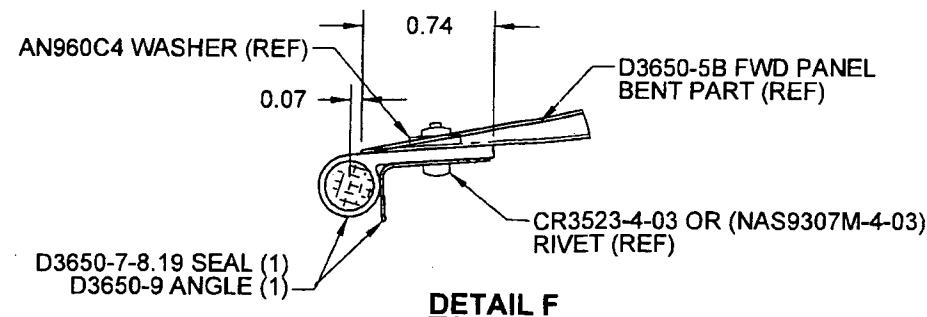
PART LIST

QTY -5	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

B

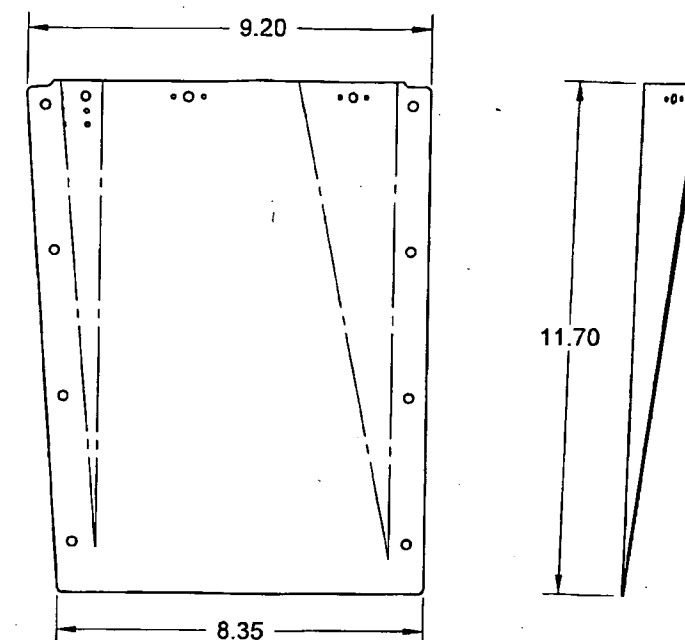
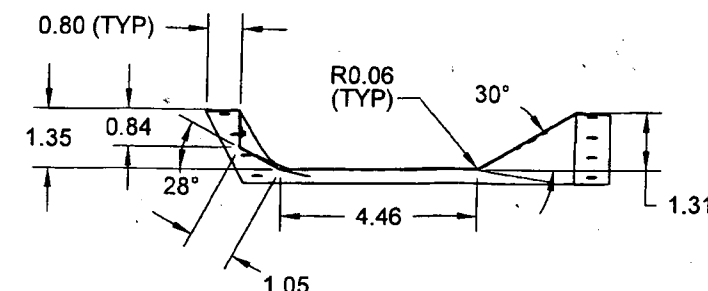
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs



D3650-5 FWD PANEL

CENTRE D3650-7-9 ON D3650-5B & TRANSFER $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3650-9 TO D3650-7 & D3650-5B AS SHOWN
INSTALL
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)



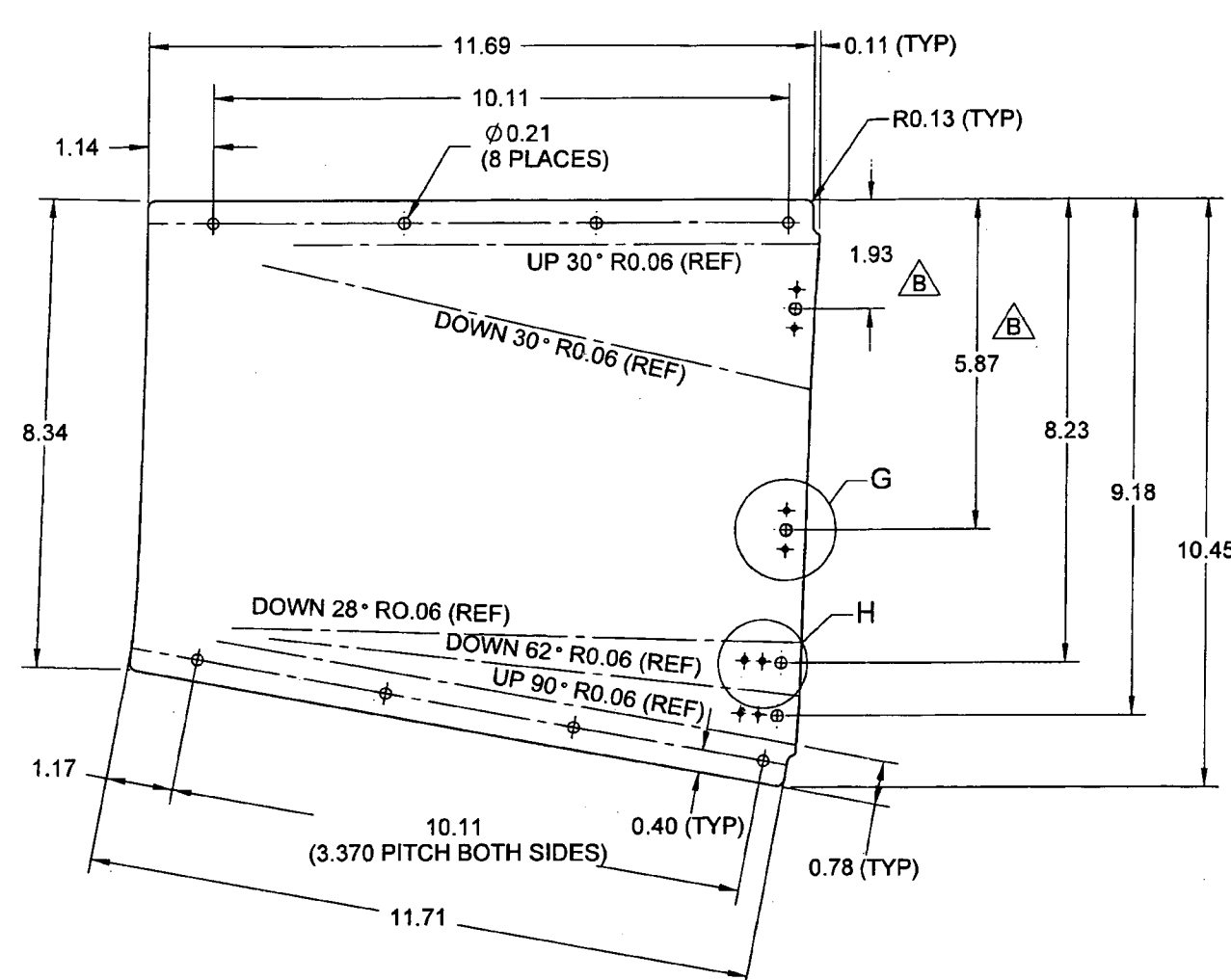
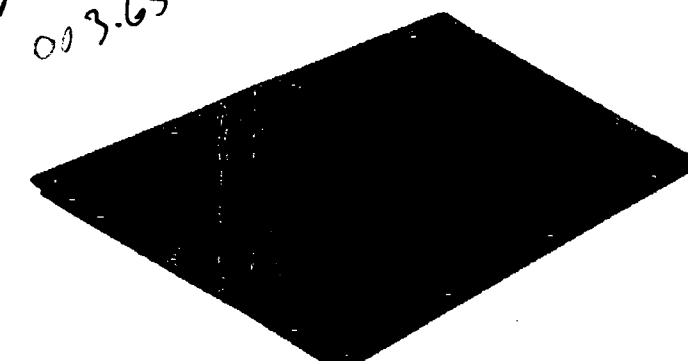
D3650-5B FWD PANEL BENT PART (MAKE FROM D3650-5F FLAT PATTERN)

RELEASED
08 03 27 / W

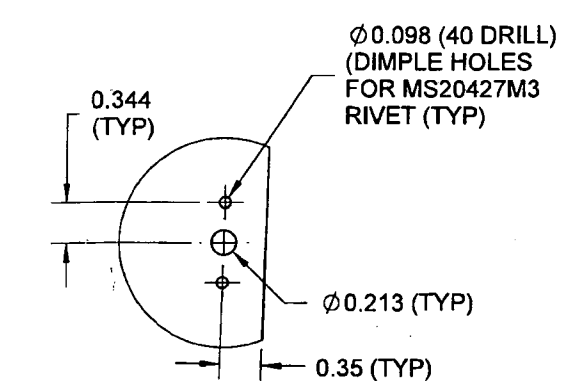
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CHECKED	VE	DRAWING NO.	REV. B
MFG. APPR.	VE	D3650	SHEET 7 OF 9
APPROVED	IMP	TITLE	SCALE
DE APPR.	IMP	TOP PANEL ASSEMBLY	1:4
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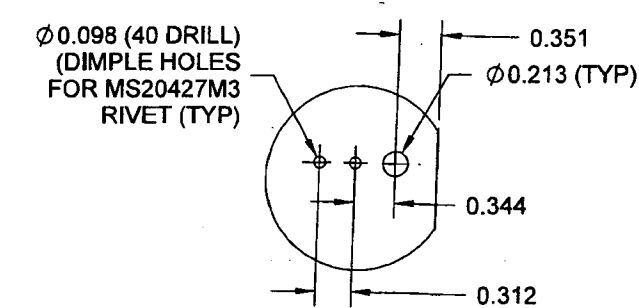
303-65
003.65



D3650-5F FLAT PATTERN



DETAIL G
(2 PLS)

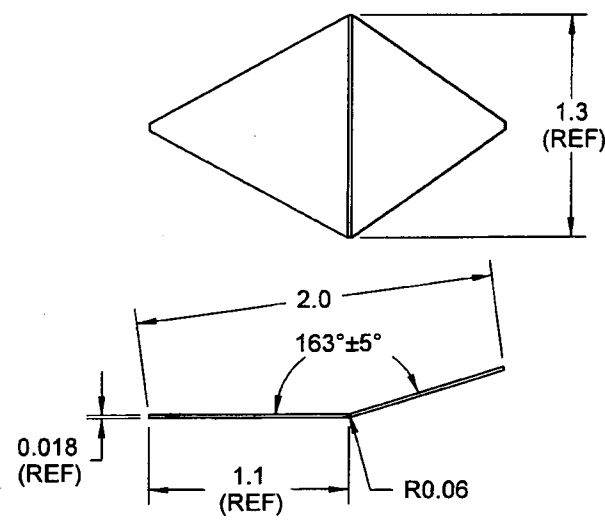


DETAIL H
(2 PLS)

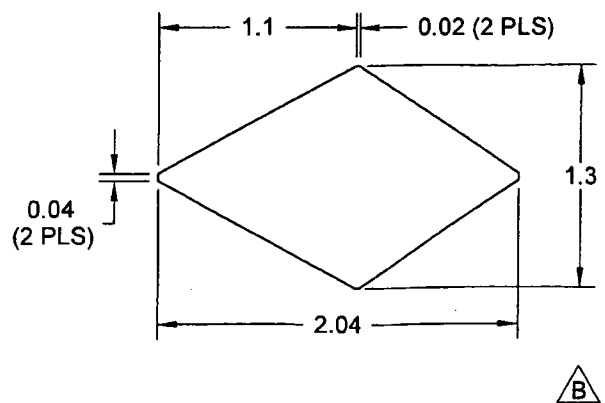
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.6 lb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	100	D3650	SHEET 8 OF 9
APPROVED	100	TITLE	SCALE
DE APPR.	100	TOP PANEL ASSEMBLY	1:3
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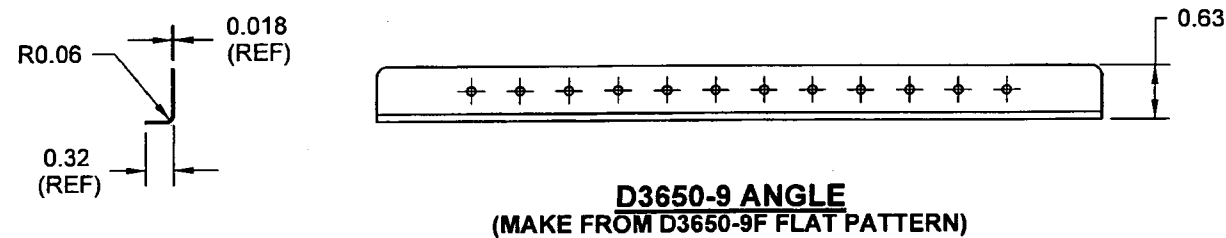
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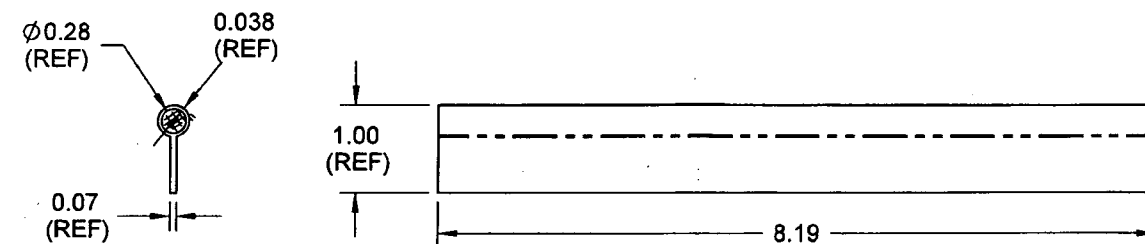
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



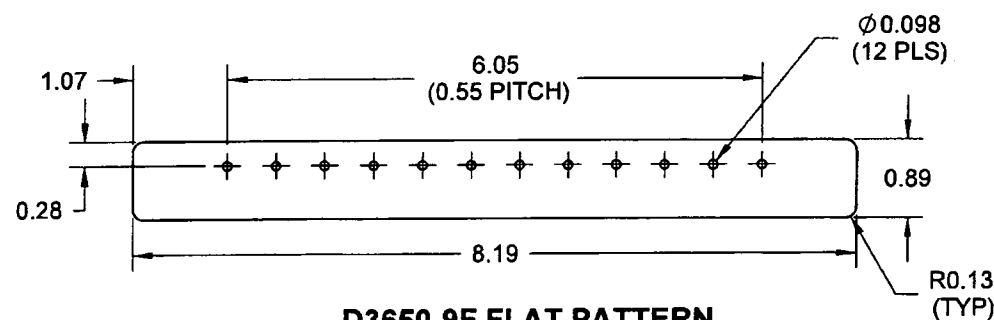
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

- D3650-7-8.19 NOTES:**
 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
 POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.05 lb
 8) PART NUMBER: D3650-7-X.XX
 WHERE X.XX = LENGTH IN INCHES
 EG. 12.50" LONG = D3650-7-12.50

- D3650-9 & D3650-11 NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
 PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) D3650-9 WEIGHT: 0.05 lb
 D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 9 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TOP PANEL ASSEMBLY	1:2
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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